

Work Order ID 119936

119936

Page 1

May-30-14 8:41:29 AM

Item ID: D350-636-013

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Skidtube LH Air Cruiser / Apical Tri-Bag Compat.

Start Date: 5/30/14 Start Qty: 1.00

1

Cust Item ID:

Required Date: 5/30/14 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: MLJ Date: 14-05-30

Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D2750-043	G

17.10.

100 Document Control 0.00

100

DOCUMENT CONTROL

DC

Memo

0.00

DAS
06
3-89

JUL 10 2014

MLJ

Doc.Control -USB or Paperwork

record fwd angle: 89.4°

Photocopy blue file and type labels per PPP D350-636-013 CHG 007

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Item ID: D350-636-013

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N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Skidtube LH Air Cruiser / Apical Tri-Bag Compat.

Start Date: 5/30/14 Start Qty: 1.00 *1*

Cust Item ID:

Required Date: 5/30/14 Req'd Qty: 1.00 *1*

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

110

0.00

110

Skidtubes

0.00

Skidtubes

Skidtubes

Memo

1- Pick D2600-3 Bent

2- Deburr FWD and AFT ends, remove bending marks. Scribe batch# inside AFT end per dwg D2750

3- Drill pilot holes for blade fitting bolt holes using DT8983. Start with 3/16", then open to 0.500" using center drill then ream holes using 0.500" reamer. PIN first side. Repeat process on second side.

ENSURE PROPER POSITIONING FWD BEND MUST BE FACING UP WHEN DRILLING FIRST SIDE

Drill pilot holes as per Dwg D2750 sheet 4 (D2750-3 details). Drill using drill Jig DT8150 & DT8864A for second side only DT8864B for first side (detail B)

4- Locate DT8330 off of blade fitting bolt holes and drill pilot holes for blade fitting. Open to 0.500" using hole saw. VERIFY AND RECORD FWD BEND ANGLE.

5- Drill only two fwd step holes using DT9616. Ensure proper positioning.

6- Drill pilot holes for wearplates as per Dwg D2750 using DT8108 open to 0.297".

7- Open up holes of Detail A to 0.297" (total of 2 holes per side)

8- Weld D2744 Cap as per Dwg D2750 and QSI 004. Fill grooves in bend left from bending as per QSI 004

14-6-28/12

14/06/04

BE14-06-04

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Item ID: D350-636-013

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N1900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Skidtube LH Air Cruiser / Apical Tri-Bag Compat.

Start Date: 5/30/14

Start Qty: 1.00

1

Cust Item ID:

Required Date: 5/30/14

Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start ***NR1***

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
StampA/R Aluminum Rod batch: *M127763*

9- Grind welds flush as per Dwg D2750

78E14-06-04

120

120

QC

Quality Control

QC10- Inspect visual per QSI004- ground welds

0.00

Memo

0.00

SMP
14/6/15

130

130

QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

SMP
14/6/15

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Item ID: D350-636-013

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N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Skidtube LH Air Cruiser / Apical Tri-Bag Compat.

Start Date: 5/30/14 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 5/30/14 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

140

Chemical Conversion Coat per QSI005 4.1

0.00

140

HandFinish

Memo

0.00

Hand Finishing

~~140~~ 14/06/10
JL DGC

150

QC7-Inspect Chemical Conversion Coat

0.00

150

QC

Memo

0.00

Quality Control

1 14/06/10

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N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Skidtube LH Air Cruiser / Apical Tri-Bag Compat.

Start Date: 5/30/14

Start Qty: 1.00

1

Cust Item ID:

Required Date: 5/30/14

Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

0.00

160

Skidtubes

0.00

Skidtubes

Memo

Skidtubes

1-Open up holes using hole saw on section AW-AW 0.500" (4 per side) as per dwg D2750

2-Open holes using hole saw on section BC-BC 0.3125" (4 per side)

3-Open up holes using uni-bit of Detail T and ground handling to 0.625" (total of 8 holes per side Detail AV-AV) as per dwg D2750.

4-Chamfer holes of section AW-AW, AV-AV, T and ground handling. (welding instructions on sheet 10)

5-Deburr and blow out all chips from inside of tube. Prepare tube for welding, remove alodine as required.

6-Bond web D2739 in place as per QSI 015, let cure for 12hrs.

A/R Sikaflex-291

batch: 128569

exp. date: 14/11/20

7- Weld spacers D3490-1, D3490-5 and D2743 as per dwg D2750 & QSI004 (welding instructions on sheet 10)

A/R Aluminum Rod

batch: m129285

8-Grind welds flush as per Dwg D2750

9-Spot face ground handling holes (total of 4 places per side) as per dwg D2750

10-Deburr holes, ensure tube is free of all scratches before sending to paint.

DC 14/06/10

- DC 14/06/10

BE14-06-12

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N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Skidtube LH Air Cruiser / Apical Tri-Bag Compat.

Start Date: 5/30/14 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 5/30/14 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

170

QC10- Inspect visual per QSI004- ground welds

0.00

DAS

27

9/89

14/6/17

170

0.00

QC

Memo

Quality Control

180

QC5- Inspect part completeness to step on W/O

0.00

DAS

27

9/89

14/6/17

180

0.00

QC

Memo

Quality Control

VERIFY C'BOARD IS GOOD

190

Pressure Wash per QSI005 4.3

0.00

190

0.00

HandFinish

Memo

Hand Finishing

Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch.

1 14/6/17

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Item ID: D350-636-013

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N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Skidtube LH Air Cruiser / Apical Tri-Bag Compat.

Start Date: 5/30/14 Start Qty: 1.00 *1*

Cust Item ID:

Required Date: 5/30/14 Req'd Qty: 1.00 *1*

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

200

0.00

200

SprayPaint

Memo

0.00

Spray Painting

1- PRIME AS PER DWG AND QSI 005 4.2
PRIMER PRC DESOTO 515X349 BATCH: 128975

2- PAINT WHITE AS PER DWG AND QSI 005 4.2
PAINT BATCH: 129269

1 CL-14-0621

210

QC14- Inspect Spray Paint

0.00

210

QC

Memo

0.00

Quality Control

Inspect for foreign object per QSI 024

164 d HL 107102

DAS
15
8-89

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Item ID: D350-636-013 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Skidtube LH Air Cruiser / Apical Tri-Bag Compat.
 Start Date: 5/30/14 Start Qty: 1.00 *1* Cust Item ID:
 Required Date: 5/30/14 Req'd Qty: 1.00 *1* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
230	HandFinishing	0.00							
230	HandFinish	0.00							
Hand Finishing	Memo								
	1- Install inserts as per dwg D2750								
	2- Inspect for Foreign Object								
	3- Install blade fitting D3488-041, wearshoes and ground handling hardware as per dwg D2750								
	SIKA FLEX 241								
	BATCH: <u>M1129457</u>								
	EXP DATE: <u>N/A</u>								
	4- Assemble o'ring to plug as per dwg D3492 and apply o'ring lube								
	A/R 55-o'ring lube batch: <u>1A (2165) 12TU 598 136K M125792 exp 156 G</u>								
	5- Coat all exposed fasteners with "LPS Procyon"								
	batch: <u>1A (2290C</u>								
240	QC5- Inspect part completeness to step on W/O	0.00							
240	QC	0.00							
Quality Control	Memo								

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Item ID: D350-636-013

Accept

N900040100

Setup Start *NS1*

Revision ID:

Item Name: Skidtube LH Air Cruiser / Apical Tri-Bag Compat.

Stop *NS2*

Start Date: 5/30/14 Start Qty: 1.00 *1*

Cust Item ID:

Required Date: 5/30/14 Req'd Qty: 1.00 *1*

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
250	Pick Kit	0.00							
250									
Packaging	Memo	0.00				/		DAS 28 9-89	JUL 07 2014 DAS 31 9-89
Packaging									
260	QC4- 100% Inspect kits for completeness	0.00							
260									
QC	Memo	0.00							
Quality Control									
270	Packaging	0.00							
270									
Packaging	Memo	0.00							
Packaging	Package as per PPP D350-636-013								

for I
loc 072

/ 8 SC
7/17/10

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Item ID: D350-636-013

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Skidtube LH Air Cruiser / Apical Tri-Bag Compat.

Start Date: 5/30/14 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 5/30/14 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

280

QC21- Final Inspection - Work Order Release

0.00

280

QC

Memo

0.00

Quality Control

MLJ 14-07-14

MLJ 14-07-11

Picklist Print

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Page 1

Work Order ID: 119936

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Parent Item: D350-636-013

D350-636-013

Parent Item Name: Skidtube LH Air Cruiser / Apical Tri-Bag Compat.

Start Date: 5/30/14

Required Date: 5/30/14

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:H02.09.25Rearranged procedure steps KJ
IPP rev I 06.03.30 Per rev. D dwg EC IPP REV:K
AS PER REV F JLM 13-08-22 VERIFIED BY :DD
IPP Rev:J 07-07-28 Added SS Wearplates(Rev E) JLM Verified By:EC
IPP Rev:K 08-09-23 revF as per dwg DD verified by:ec IPP Rev:L
10.06.22 revise seq110 DD verf:EC IPP Rev:M 10.10.01 as
per IIN revH DD verf:EC IPP REV:N 13.08.27 PER ECN13-
594 DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2743		Manufactured	No				Each	124.0000		8			

D2743

Crossbolt Spacer

**

B214-06-11

Location	Loc Qty	Loc Code
LG	123	
111570	8	
112729	115	
LG001	1	
109799	1	

D2600-3-BENT

Manufactured No

110

Each

8.0000

1

1

D2600-3-BENT

Extrusion Bent

**

Location	Loc Qty	Loc Code
LG	7	
117904	7	
LG002	1	
112976	1	

14-06-02 PLW

Picklist Print

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Work Order ID: 119936

119936

Parent Item: D350-636-013

D350-636-013

Parent Item Name: Skidtube LH Air Cruiser / Apical Tri-Bag Compat.

Start Date: 5/30/14

Required Date: 5/30/14

Start Qty: 1.00

Required Qty: 1.00

D3493-1

Manufactured No

110

Each

199.0000

2

2

D3493-1

Washer

******DAS
28
9-89

JUL 07 2014

DAS
06
9-89LocationLoc QtyLoc Code

FG

10

97201

10

ST051

189

109105

159

112741

30

2X

DAS
31
9-89***ONLY INSTALL IF INSTALLING ON APICAL
FLOAT SYSTEM***

D2739

Manufactured No

160

Each

12.0000

1

1

D2739

350 I Beam

DE 14/06/10

LocationLoc QtyLoc Code

LG

5

111094

1

113252

1

117803

3

LG002

7

115881

7

①

D2744

Manufactured No

160

Each

21.0000

1

1

D2744

Cap

BE 14-06-04

LocationLoc QtyLoc Code

LG001

21

115440

21

1

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Parent Item: D350-636-013

D350-636-013

Parent Item Name: Skidtube LH Air Cruiser / Apical Tri-Bag Compat.

Start Date: 5/30/14

Required Date: 5/30/14

Start Qty: 1.00

Required Qty: 1.00

D3490-1 Manufactured No 160 Each 115.0000 4 4

D3490-1

Cross Bolt Spacer

******BB14-06-17LocationLoc QtyLoc Code

LG

115

112737

1

116358

114

D3490-5 Manufactured No 160 Each 32.0000 4 4

D3490-5

Cross Bolt Spacer

******BB14-06-17LocationLoc QtyLoc Code

LG001

32

109104

32

ALS4-1032-225 AELS8-1032-225 Purchased No 230 Each 765.0000 38 38

ALS4-1032-225

Rivnut

******ju 11/07/02LocationLoc QtyLoc Code

FG

30

M127028

30

FP001

461

M128649

461

ST280

248

M127028

10

M128179

238

st555

26

M127092

26

x38

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Parent Item: D350-636-013

D350-636-013

Parent Item Name: Skidtube LH Air Cruiser / Apical Tri-Bag Compat.

Start Date: 5/30/14

Required Date: 5/30/14

Start Qty: 1.00

Required Qty: 1.00

AN3C5A Purchased No 230 Each 1,027.000 34 34

AN3C5A

Bolt

lll 11/07/02

Location Loc Qty Loc Code

FG 5

122800 5

ST350 422

M128973 222

M129198 200

ST513 600

M128911 600

X34

AN3C6A Purchased No 230 Each 1,265.000 4 4

AN3C6A

Bolt

lll 11/07/02

Location Loc Qty Loc Code

FG 10

122416 10

ST351 2

m128224 2

ST513 1253

m125709 257

m128769 996

X4

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Parent Item: D350-636-013

D350-636-013

Parent Item Name: Skidtube LH Air Cruiser / Apical Tri-Bag Compat.

Start Date: 5/30/14

Required Date: 5/30/14

Start Qty: 1.00

Required Qty: 1.00

AN6C44A

Purchased

No

230

Each

127.0000

4

4

AN6C44A******

Bolt

LocationLoc QtyLoc Code

FG

2

103964

2

ST341

28

m128319

28

ST505

97

m128700

47

m129199

50

✓

11/07/02

AN8C35A

Purchased

No

230

Each

55.0000

1

1

AN8C35A******

Bolt

LocationLoc QtyLoc Code

FG

4

121275

4

FP001

51

m126293

29

m127823

22

X1

11/07/02

D2745

Manufactured

No

230

Each

78.0000

8

8

D2745******

Bushing

LocationLoc QtyLoc Code

ST017

78

107336

4

111554

8

113176

58

90323

2

93336

6

B117099

X2

11/07/02

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Parent Item Name: Skidtube LH Air Cruiser / Apical Tri-Bag Compat.

Start Date: 5/30/14

Required Date: 5/30/14

Start Qty: 1.00

Required Qty: 1.00

D3488-041 Manufactured No

230

Each

9.0000

1

1

D3488-041

Blade Fitting LH

11/07/14

Location

Loc Qty

Loc Code

FP001

9

111463

8

88255

1

D3492-1 Manufactured No

230

Each

144.0000

8

8

D3492-1

Plug

11/07/14

Location

Loc Qty

Loc Code

FP001

144

111578

2

112738

8

114879

134

D3492-5 Manufactured No

230

Each

129.0000

8

8

D3492-5

Plug

N/A PTO last page ->

Location

Loc Qty

Loc Code

FP001

129

104854

9

105612

39

112740

81

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Parent Item: D350-636-013

D350-636-013

Parent Item Name: Skidtube LH Air Cruiser / Apical Tri-Bag Compat.

Start Date: 5/30/14

Required Date: 5/30/14

Start Qty: 1.00

Required Qty: 1.00

D3535-25

Manufactured No

230

Each

28.0000

1

1

D3535-25

Wearplate Center

all 10/07/02

Location

Loc Qty

Loc Code

FG

2

95077

2

FP002

26

110744

1

115750

11

118933

13

93278

1

✓

D3536-25

Manufactured No

230

Each

17.0000

1

1

D3536-25

Gasket Center

all 10/07/02

Location

Loc Qty

Loc Code

FG

6

87053

2

95328

4

FP001

11

110652

1

117687

9

93696

1

✓

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Work Order ID: 119936

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Parent Item: D350-636-013

D350-636-013

Parent Item Name: Skidtube LH Air Cruiser / Apical Tri-Bag Compat.

Start Date: 5/30/14

Required Date: 5/30/14

Start Qty: 1.00

Required Qty: 1.00

D3537-1

Manufactured No

230

Each

37.0000

3

3

D3537-1

Wearpad

ll 11/07/02

Location

Loc Qty

Loc Code

FG

18

B115586

v3

79833

8

88562

10

FP001

19

113229

6

113358

8

113839

4

93945

1

D3631-1

Manufactured No

230

Each

180.0000

8

8

D3631-1

Washer

ll 11/07/02

Location

Loc Qty

Loc Code

FP001

180

B

110258

16

111019

12

115800

52

119553

100

v2

D3791-1

Manufactured No

230

Each

12.0000

1

1

D3791-1

Wearpad

ll 11/07/02

Location

Loc Qty

Loc Code

FP001

1

92689

1

FP002

11

110982

3

113136

8

x1

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Parent Item: D350-636-013

D350-636-013

Parent Item Name: Skidtube LH Air Cruiser / Apical Tri-Bag Compat.

Start Date: 5/30/14

Required Date: 5/30/14

Start Qty: 1.00

Required Qty: 1.00

D3793-1

Manufactured No

230

Each

12.0000

1

1

D3793-1

Wearplate Fwd

******HL 11/07/02LocationLoc QtyLoc Code

FP002

12

112741

2

115686

9

92382

1

D3793-3

Manufactured No

230

Each

12.0000

1

1

D3793-3

Wearplate Aft

******HL 11/07/02LocationLoc QtyLoc Code

FP001

1

104212

1

FP002

11

115604

10

92487

1

D3794-1

Manufactured No

230

Each

16.0000

1

1

D3794-1

Gasket Fwd

******HL 11/07/02LocationLoc QtyLoc Code

FP001

16

109207

1

111574

1

115838

13

93381

1

Picklist Print

Page 10

May-30-14 8:41:32 AM

Work Order ID: 119936

119936

Parent Item: D350-636-013

D350-636-013

Parent Item Name: Skidtube LH Air Cruiser / Apical Tri-Bag Compat.

Start Date: 5/30/14

Required Date: 5/30/14

Start Qty: 1.00

Required Qty: 1.00

D3794-3 Manufactured No 230 Each 5.0000 1 1

D3794-3

Gasket Aft

**

ll 11/07/02

Location

Loc Qty

Loc Code

FP001

5

B119328

xl

115659

4

92658

1

MS21043-6

Purchased No

230

Each

218.0000

4

4

MS21043-6

NUT

**

ll 11/07/02

Location

Loc Qty

Loc Code

FG

20

103693

20

ST315

10

m127255

10

ST509

188

m127813

188

x4

MS21083C8

Purchased No

230

Each

161.0000

1

1

MS21083C8

Nut

**

ll 11/07/02

Location

Loc Qty

Loc Code

ST319

11

m127255

5

m128119

6

ST508

150

m128798

150

yl

May-30-14 8:41:32 AM

Shop Packet Print

Page 10

Picklist Print

May-30-14 8:41:32 AM

Work Order ID: 119936

119936

Parent Item: D350-636-013

D350-636-013

Parent Item Name: Skidtube LH Air Cruiser / Apical Tri-Bag Compat.

Start Date: 5/30/14

Required Date: 5/30/14

Start Qty: 1.00

Required Qty: 1.00

NAS1149C0332R

Purchased

No

230

Each

5,700.000

38

38

NAS1149C0332R

WASHER

ll 11/03/02

Location

Loc Qty

Loc Code

GA

825

125654

825

Return2014

41

122063

41

ST292

1676

124580

8

125654

8

m128591

1660

st510

3158

m126319

61

m127306

2500

m127410

563

m127831

34

11129499

x38

NAS1149C0832R

Purchased

No

230

Each

290.0000

1

1

NAS1149C0832R

Washer

ll 11/07/07

Location

Loc Qty

Loc Code

ST292

290

122441

23

m114915

117

m125807

150

x1

Picklist Print

May-30-14 8:41:32 AM

Page 12

Work Order ID: 119936

119936

Parent Item: D350-636-013

D350-636-013

Parent Item Name: Skidtube LH Air Cruiser / Apical Tri-Bag Compat.

Start Date: 5/30/14

Required Date: 5/30/14

Start Qty: 1.00

Required Qty: 1.00

NAS1515H3L

Purchased

No

230

Each

483.0000

4

4

***NAS1515H3I ***

Washer

******ll 11/07/02LocationLoc QtyLoc Code

FG

40

102472

40

ST297

443

m127831

159

m128976

284

NAS1611-005

Purchased

No

230

Each

171.0000

8

8

NAS1611-005

O-RING

******nila pto last page ->LocationLoc QtyLoc Code

FP001

171

m126974

96

m129198

75

NAS1611-010

Purchased

No

230

Each

195.0000

8

8

NAS1611-010

O-RING

******ll 11/07/02LocationLoc QtyLoc Code

FP001

195

m126988

3

m127813

4

m128375

80

m128388

8

m129198

100

M 129405

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Shop Packet Print

Page 12

Picklist Print

May-30-14 8:41:32 AM

Page 13

Work Order ID: 119936

119936

Parent Item: D350-636-013

D350-636-013

Parent Item Name: Skidtube LH Air Cruiser / Apical Tri-Bag Compat.

Start Date: 5/30/14

Required Date: 5/30/14

Start Qty: 1.00

Required Qty: 1.00

AN8C21A

Purchased

No

250

Each

49.0000

2

2

AN8C21A

Bolt

DAS
28
9-89

JUL 07 2014

DAS
06
9-89

Location

Loc Qty

Loc Code

ST

2

123966

2

ST341

2

m127061

2

ST342

3

m128319

2

m128849

1

ST508

42

m127823

42

2X

D2741

Manufactured

No

250

Each

34.0000

1

1

D2741

Blade

121976

7.0

2

DAS
06
9-89

Location

Loc Qty

Loc Code

FG

14

100664

5

115522

5

98323

4

FP001

1

88824

1

ST466

19

107206

2

113640

12

115522

5

May-30-14 8:41:32 AM

Shop Packet Print

Page 13

Picklist Print

Page 14

May-30-14 8:41:32 AM

Work Order ID: 119936

119936

Parent Item: D350-636-013

D350-636-013

Parent Item Name: Skidtube LH Air Cruiser / Apical Tri-Bag Compat.

Start Date: 5/30/14

Required Date: 5/30/14

Start Qty: 1.00

Required Qty: 1.00

MS21083C8

Purchased

No

250

Each

161.0000

2

2

MS21083C8

DAS
28
9-89

JUL 07 2014

Nut

DAS
06
9-89

Location

Loc Qty

Loc Code

ST319

11

m127255

5

m128119

6

ST508

150

m128798

150

2x

NAS1149D0863J

Purchased

No

250

Each

859.0000

2

2

NAS1149D0863.J

DAS
28
9-89

DAS
31
9-89

Washer

DAS
06
9-89

Location

Loc Qty

Loc Code

FP001

2

118078

2

ST293

57

125484

57

2x

ST510a

800

125268

600

125635

200

May-30-14 8:41:32 AM

Shop Packet Print

Page 14

QTY -041	QTY -042	QTY -043	QTY -044	PART NUMBER	DESCRIPTION
X				D2750-041	350 SKIDTUBE ASSEMBLY, LH
	X			D2750-042	350 SKIDTUBE ASSEMBLY, RH
		X		D2750-043	350 SKIDTUBE ASSEMBLY, LH
			X	D2750-044	350 SKIDTUBE ASSEMBLY, RH
1	1	1	1	D2739	WEB
8	8	8	8	D2743	SPACER
1	1	1	1	D2744	CAP
8	8	8	8	D2745	BUSHING
1				D2750-1	SKIDTUBE WELDMENT, LH
	1			D2750-2	SKIDTUBE WELDMENT, RH
		1		D2750-3	SKIDTUBE WELDMENT, LH
			1	D2750-4	SKIDTUBE WELDMENT, RH
1		1		D3488-041	BLADE FITTING, LH
	1		1	D3488-042	BLADE FITTING, RH
4	4	4	4	D3490-1	SPACER
4	4			D3490-3	SPACER
		4	4	D3490-5	SPACER
8	8	8	8	D3492-041	PLUG ASSEMBLY
8	8			D3492-043	PLUG ASSEMBLY
		8	8	D3492-045	PLUG ASSEMBLY
1	1	1	1	D3535-25	WEARSHOE
1	1	1	1	D3536-25	GASKET
3	3	3	3	D3537-1	WEARPAD
8	8	8	8	D3631-1	WASHER
1	1	1	1	D3791-1	WEARPLATE
1	1	1	1	D3793-1	WEARSHOE
1	1	1	1	D3793-3	WEARSHOE
1	1	1	1	D3794-1	GASKET
1	1	1	1	D3794-3	GASKET
38	38	38	38	ALS4-1032-225	INSERT (OR ALS7-1032-225, AKS4-1032-225, AELS-1032-225)
34	34	34	34	AN3C5A	BOLT
4	4	4	4	AN3C6A	BOLT
4	4	4	4	AN6C44A	BOLT
1	1	1	1	AN8C35A	BOLT
38	38	38	38	AN960C10L	WASHER
1	1	1	1	AN960C816L	WASHER
4	4	4	4	MS21043-6	NUT
1	1	1	1	MS21083C8	NUT
4	4	4	4	NAS1515H3L	WASHER

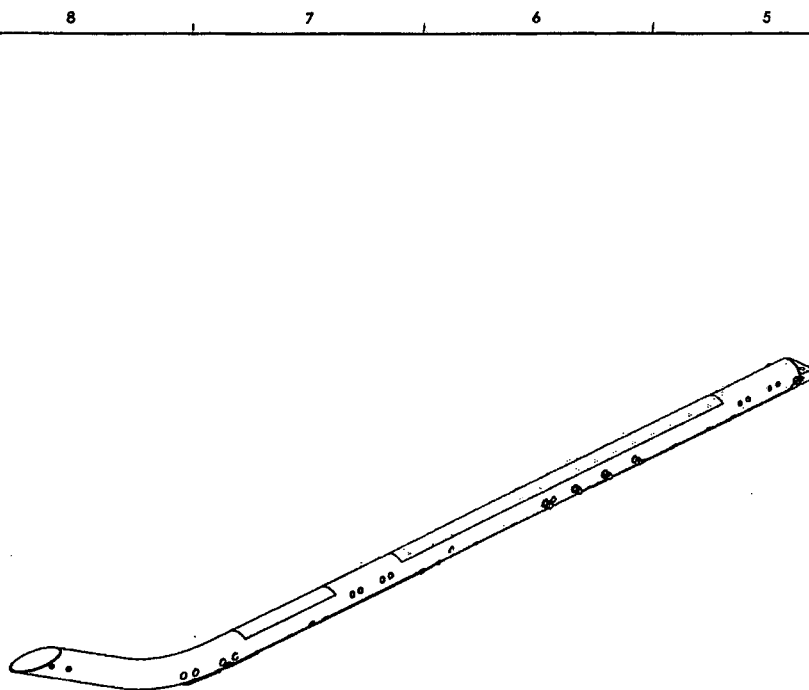
GENERAL NOTES:

- MATERIAL: MAKE D2750-1/-2/-3/-4 FROM D2600-3 EXTRUSION (INITIAL LENGTH = 120.0).
- FINISH: ACID ETCH, ALODINE ASSEMBLY PER DART QSI 005 4.1 PRIOR TO INSTALLING D2739 WEB.
 STANDARD: PRIME (REF. 4.2.1.3.3) AND PAINT WHITE PER DART QSI 005 4.2
 OPTIONAL: POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
 BLACK ANTI-SKID PAINT AS INDICATED TO 1.0 ABOVE SKIDTUBE CENTER-LINE PER DART 005 4.4 (OPTIONAL).
- TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- UNITS: INCHES UNLESS OTHERWISE NOTED
- BREAK SHARP EDGES: N/A
- IDENTIFICATION: N/A
- WEIGHT: D2750-041/-042/-043/-044 = 26.5 LBS
- WELD PER DART QSI 004
- INSTALL ALS4-1032-225 INSERTS AFTER FINISH AS INDICATED. DRILL 'F' SIZE HOLES ($\phi 0.297$) FOR WEARSHOE INSERTS
- FINAL CONFIGURATION SHOULD HAVE THE FOLLOWING MINIMUM MECHANICAL PROPERTIES:
 MINIMUM YIELD TENSILE STRENGTH = 35 KSI
 MINIMUM ULTIMATE TENSILE STRENGTH = 38 KSI
- COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF
 FINISH WITH MEK DEGREASER.
- SPACER AND PLUG INSTALLED SAME AS SECTION AJ-AJ EXCEPT HORIZONTAL
- SPACER AND PLUG INSTALLED SAME AS SECTION AP-AP EXCEPT HORIZONTAL

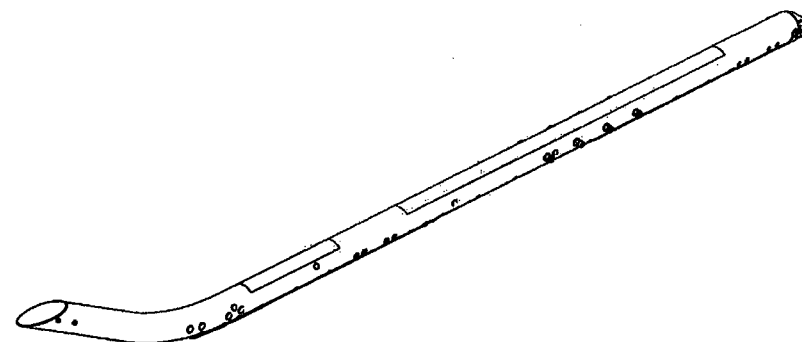
SHOP COPY
 RETURN TO
 ENGINEERING
 UNCONTROLLED COPY
 SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 WORK ORDER
 NO. 119936 MJS
 14-05-30

RELEASED
 2013-08-13
 WD

G	CORRECTED TOLERANCE ON $\phi 0.500$ THRU HOLE: IS +0.010/-0.000, WAS +0.100/-0.000 (ZN B3-4, B2-5); ADD VIEW TO CONTROL FWD BEND ORIENTATION (ZN D-1-4/-5-6/-7); UPDATED FINISH OPTIONS; INSIDE OF TUBE NO LONGER SPRAYED WITH LPS-3. REASON: PAR13-276 AND NCR13-2757	MB	13.07.11
F	INCORPORATE DSI 9413; QTY (3) D3537-1 WAS QTY (5) (ZN C8-1); D3791-1/-3 REPLACES D3535-13/-35 (ZN C8-1); D3794-1/-3 REPLACES D3536-13/-35 (ZN B8-1); ADD D3791-1 (ZN C8-1); WEARSHOE HOLES UNDER FWD/AFT SADDLE REMOVED (8 PL). WEARSHOE HARDWARE QTY UPDATED (ZN B8-1); D3488-041/-042 HARDWARE UPDATED (ZN C1-8, 9, 10, 11); ADD NOTE 12 AND 13 (ZN A6-1); REASON: REF. NCR 08-043	PH	08.07.16
E	CHANGE TO STAINLESS STEEL WEARPLATES; ADD RUBBER GASKETS; CHANGE INSERTS; ADD D3631-1; REMOVE QTY (38) NAS1515H3L; REMOVE QTY (10) NAS1515H8L; REMOVE D2741; QTY (2) AN960C816; REMOVE QTY (2) MS21083C8	CB	07.05.17
D	ADD HOLES AND SPACERS FOR APICAL FLOATS; INCORPORATE DEO 9133/9157	PH	06.01.05
C	ADD D2750-3/D2750-4; INCORPORATE D2738 AND D2740	CP	98.11.18
B	CHANGE MS24694-S293 TO AN8-16A	CP	98.09.01
A	NEW ISSUE	DS	98.04.16
REV.	DESCRIPTION	BY	DATE
DESIGN	MM	DART AEROSPACE USA, INC.	
DRAWN	B	KENT, WA	
CHECKED	JP	DRAWING NO.	REV. G
MFG. APPR.	JP	D2750	SHEET 1 OF 11
APPROVED	JP	TITLE	SCALE
DE APPR.	JP	350 SKIDTUBE ASSEMBLY	NTS
DATE	13.07.11	COPYRIGHT © 1988 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS UNCLASSIFIED AND IS RELEASED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	



D2750-041 350 SKIDTUBE ASSEMBLY, LH



D2750-042 350 SKIDTUBE ASSEMBLY, RH

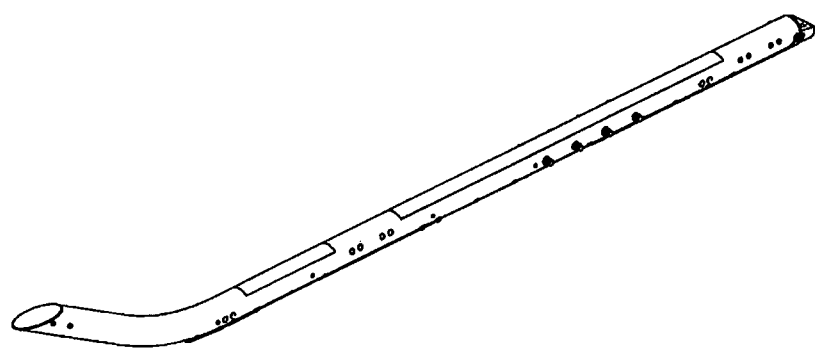
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2013-08-13
MD

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CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. G
MFG. APPR.	<i>[Signature]</i>	D2750	SHEET 2 OF 11
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DE APPR.	<i>[Signature]</i>	350 SKIDTUBE ASSEMBLY	NTS
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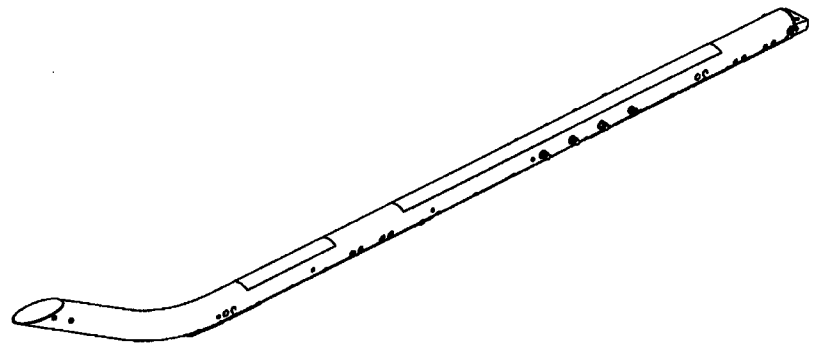
8 7 6 5 4 3 2 1

D
C
B
A

D
C
B
A



D2750-043 350 SKIDTUBE ASSEMBLY, LH

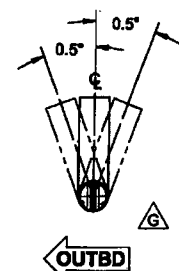
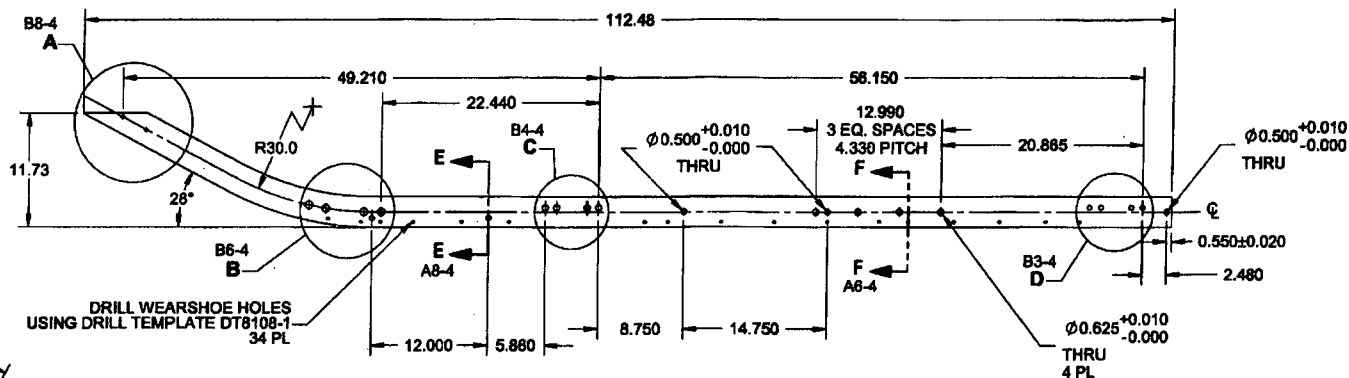


D2750-044 350 SKIDTUBE ASSEMBLY, RH

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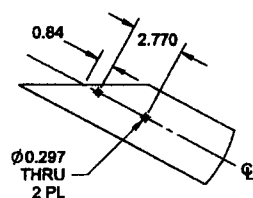
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DRAWN		KENT, WA	
CHECKED		DRAWING NO.	REV. G
MFG. APPR.		D2750	SHEET 3 OF 11
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8 7 6 5 4 3 2 1

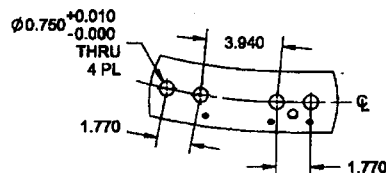


MAX ALLOWABLE
TWIST ON FWD BEND
(VIEWED LOOKING FWD)

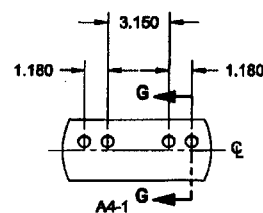
D2750-1 LH SKIDTUBE



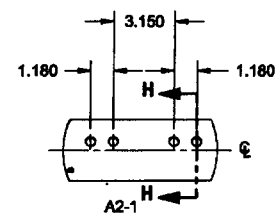
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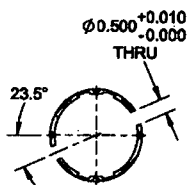
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SCALE 2X



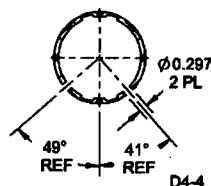
DETAIL C
SCALE 2X



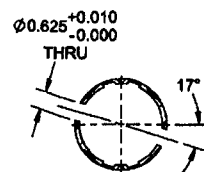
DETAIL D
SCALE 2X



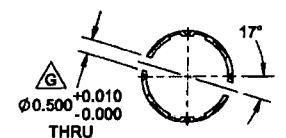
SECTION E-E
SCALE 3X, 2 PL



SECTION F-F
SCALE 3X, 17 PL



SECTION G-G
SCALE 3X, 4 PL

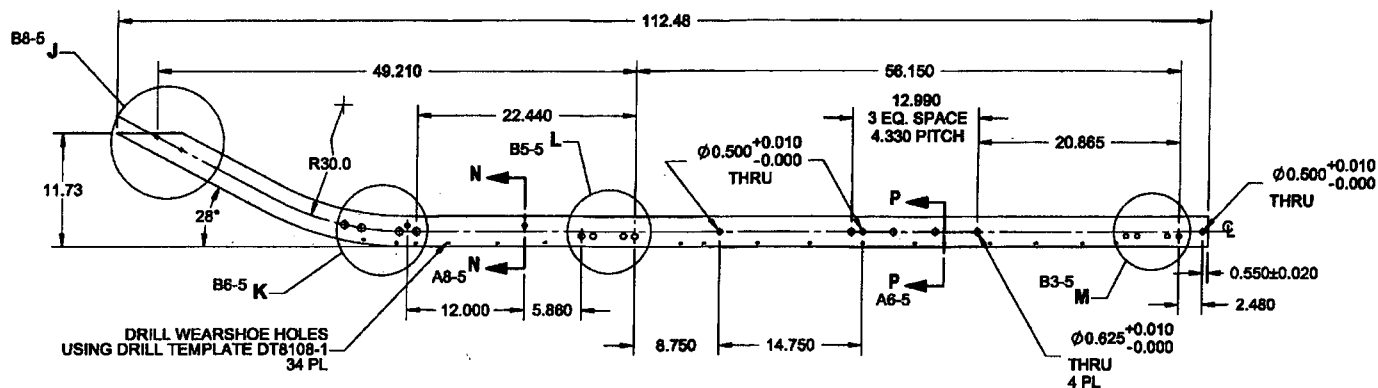


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SCALE 3X, 4 PL

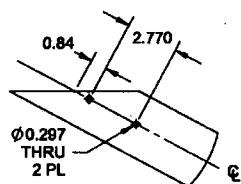
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DRAWN		KENT, WA
CHECKED		DRAWING NO. D2750
MFG. APPR.		REV. G
APPROVED		SHEET 4 OF 11
DE APPR.		TITLE 350 SKIDTUBE ASSEMBLY
DATE 13.07.11		SCALE NTS

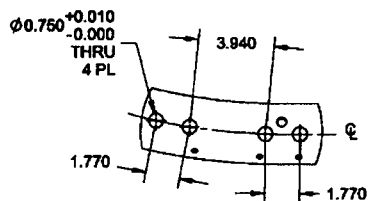
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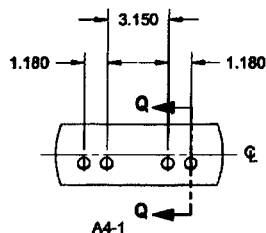
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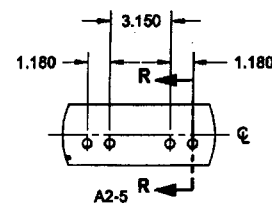
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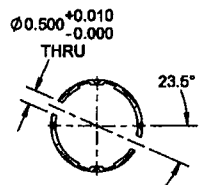
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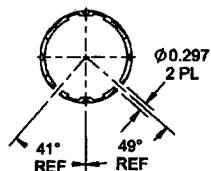
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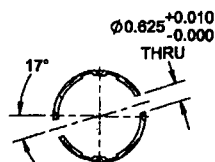
DETAIL M
SCALE 2X



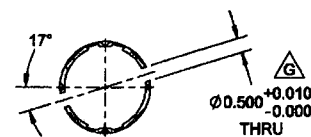
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SCALE 3X, 2 PL



SECTION P-P
SCALE 3X, 17 PL



SECTION Q-Q
SCALE 3X, 4 PL








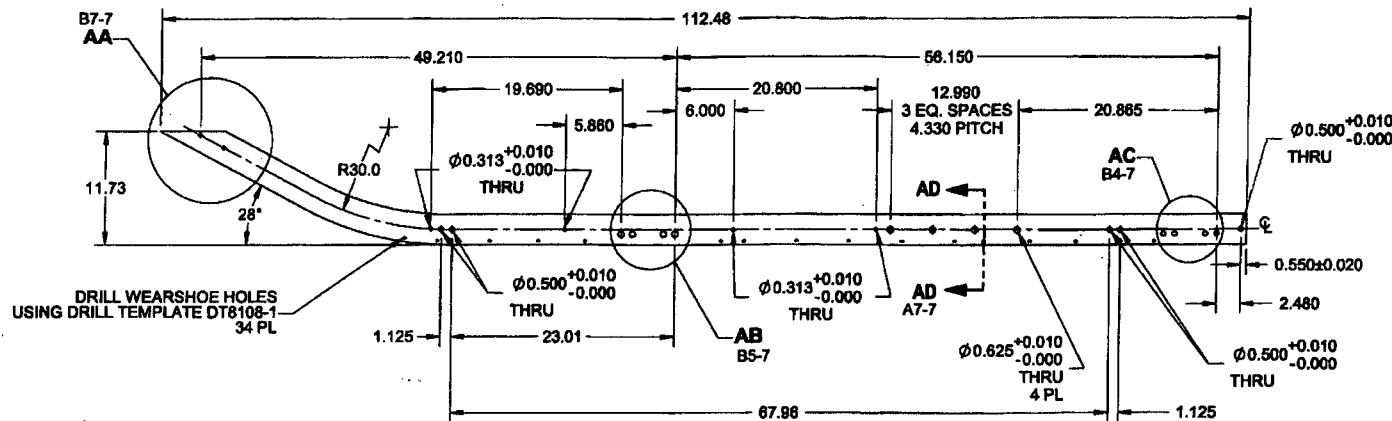
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2013-08-13

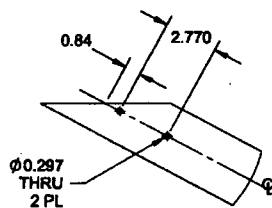
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CHECKED		DRAWING NO.	REV. G
MFG. APPR.		D2750	SHEET 5 OF 11
APPROVED		TITLE	SCALE
DE APPR.		350 SKIDTUBE ASSEMBLY	NTS
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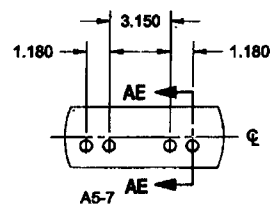
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DRAWN		KENT, WA	
CHECKED		DRAWING NO.	REV. 0
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DE APPR.		350 SKIDTUBE ASSEMBLY	NTS
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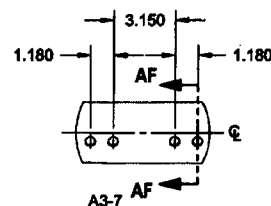
D2750-4 RH SKIDTUBE



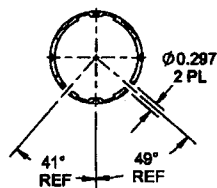
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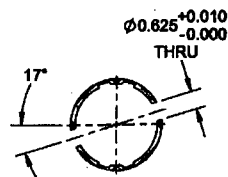
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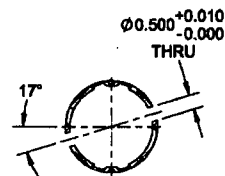
DETAIL AC
SCALE 2X



SECTION AD-AD
SCALE 3X, 17 PL



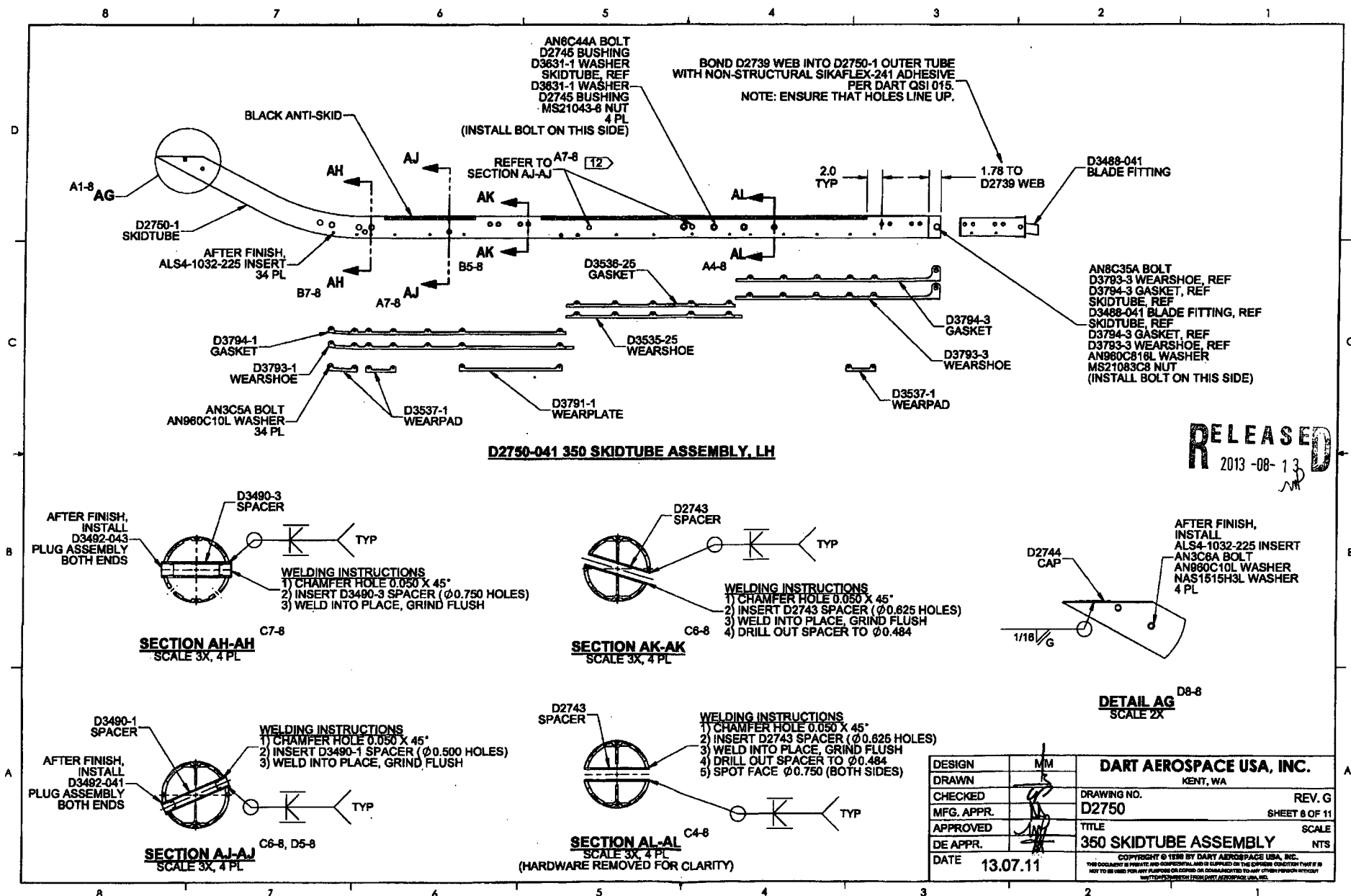
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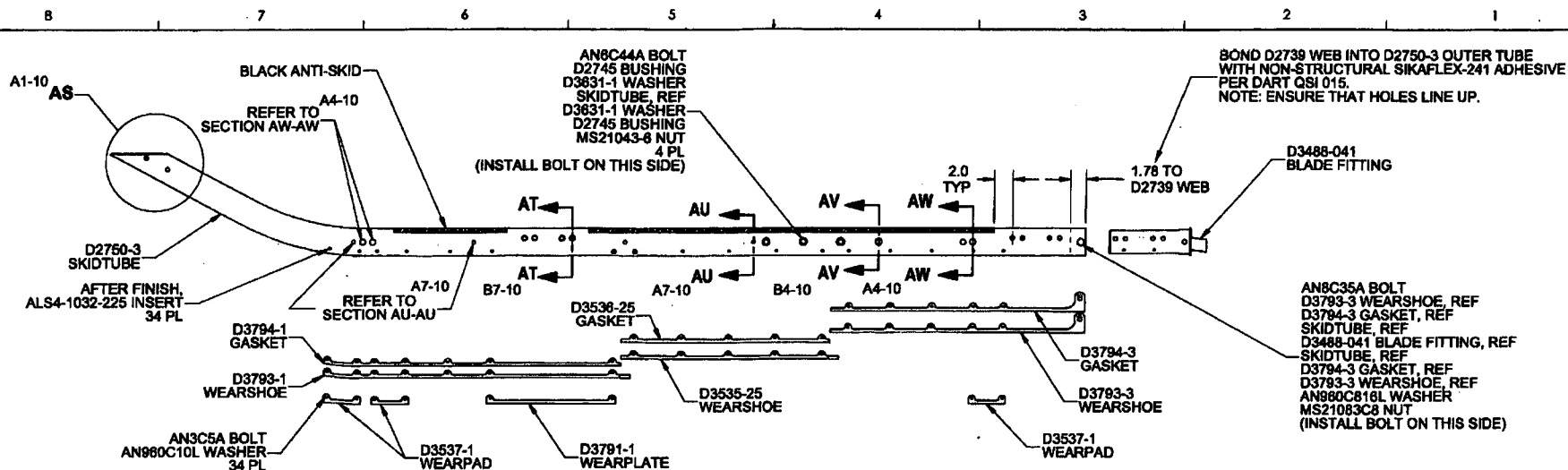


SECTION AF-AF
SCALE 3X, 4 PL

RELEASED
2013-08-13

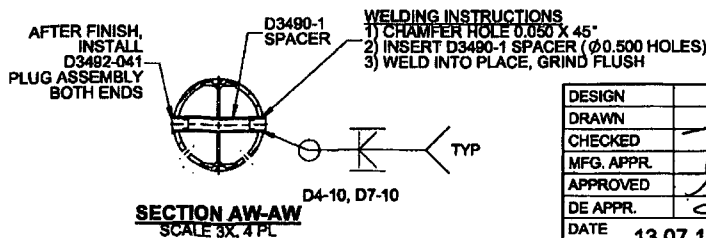
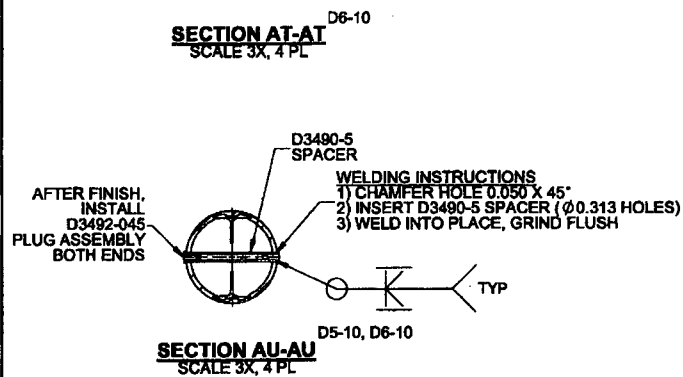
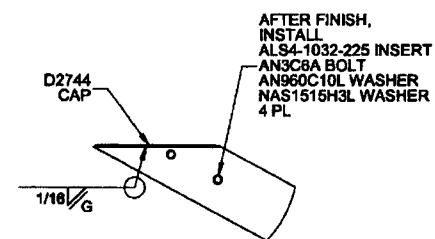
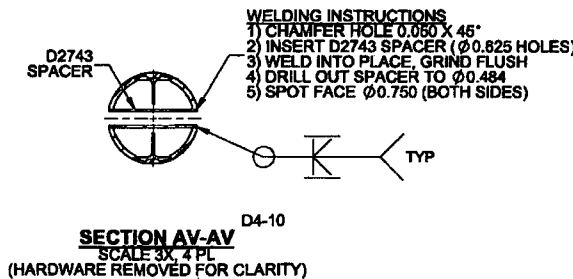
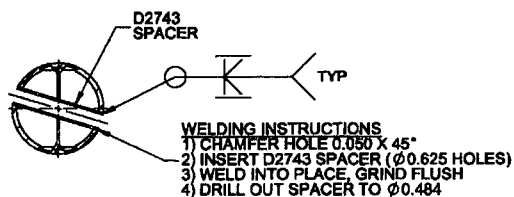
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MFG. APPR.		D2750	SHEET 7 OF 11
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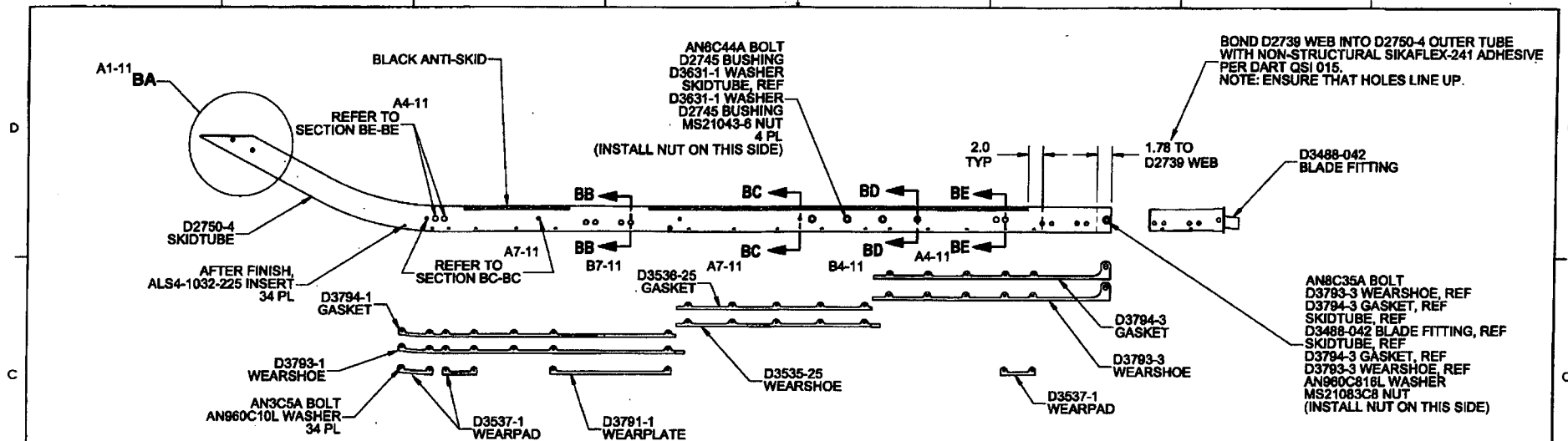
D2750-043 350 SKIDTUBE ASSEMBLY, LH

RELEASE
2013-08-13

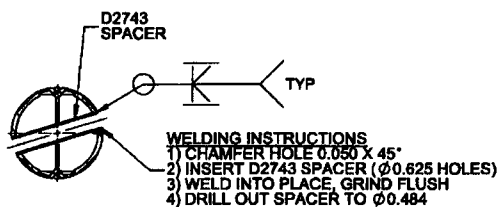


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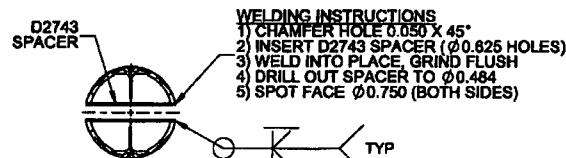
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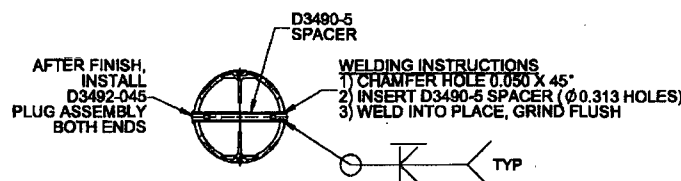
D2750-044 350 SKIDTUBE ASSEMBLY, RH



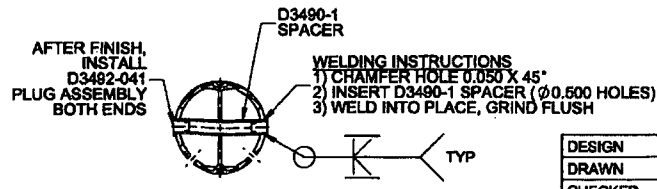
SECTION BB-BB
SCALE 3X, 4 PL



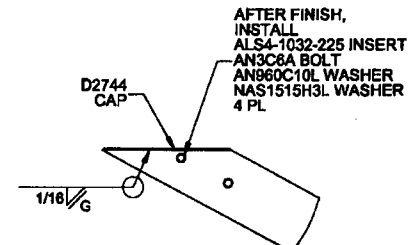
SECTION BD-BD
SCALE 3X, 4 PL
(HARDWARE REMOVED FOR CLARITY)



SECTION BC-BC
SCALE 3X, 4 PL



SECTION BE-BE
SCALE 3X, 4 PL



DETAIL BA
SCALE 2X

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RELEASED
2013-08-13

Linda Lacelle

From: David Shepherd
Sent: June-24-14 1:00 AM
To: Chris Provencal
Cc: Mike Petsche; Linda Lacelle
Subject: RE: plugs on skidtubes

Chris,

Sorry for the delay in getting back to you on this.

If these are the only plugs that we are having a problem with, then I am OK with leaving them out of the skidtubes since the holes that are being plugged are so small. Seems weird to me that we've suddenly started to have a problem, but whatever.

Can I assume from your email that the rest of the plugs are OK?

Regards,
David

From: Chris Provencal
Sent: June-04-14 10:59 AM
To: David Shepherd
Cc: Mike Petsche
Subject: RE: plugs on skidtubes

David,

When installing D3492-045 plugs into the 3/16" holes for D4168-043 Skidtubes (AS 350), the o-rings are ripping. See the attached photos for one of the plugs. The effected hole is section AU-AU from the attached pdf page. This is causing some of the plugs to fall out when handling them.

I tried a new plug (D3492-5) and new o-ring (NAS1611-005) with an unpainted D3890-5 spacer (0.197 ID) and could not get it installed without the same ripping. We enlarged a spacer to 0.206" ID and put a 0.220"x45deg c'sink (about the OD of the o-ring) hoping it would force the o-ring into the hole. It ripped less, but the o-ring just doesn't want to compress that much. Some of the o-ring always wants to squeeze out and it gets sheared off when you try to force the plug in (it takes a lot of force to get it in).

I don't know how we've been doing this in the past. We only noticed the problem this time during final packaging of the latest batch.

Linda Lacelle

From: Patrick Smith
Sent: May-29-14 1:29 PM
To: Linda Lacelle; Mike Petsche
Cc: Nigel Forbes; Eric Downing; Nancy MacLeod; David Shepherd
Subject: RE: 350 skids and 206 skids

PAR 14-338

Linda,

I spoke with David and he would allow us to use a RTV product to bond the Plugs into the Skidtube.

The existing Plugs would require:

- 1) Removal from the Skidtube
- 2) Removal of the current O-Ring
- 3) Cleaning with Alcohol
- 4) Installation of NEW O-Ring
- 5) Generous coating of the RTV
- 6) Insertion of plug into the Spacer
- 7) Clean up of exterior of Skidtube.

Pat

From: Linda Lacelle
Sent: May-29-14 10:21 AM
To: Mike Petsche
Cc: Nigel Forbes; Patrick Smith; Eric Downing; Nancy MacLeod
Subject: 350 skids and 206 skids
Importance: High

I heard yesterday that plugs were falling out. Today we were told that we cannot ship any 350 skids. We have an order to ship today, has there been a solution found to fix this problem? Can we not just sikaflex them in or something? We need to let the customer know if his order is shipping or not...

Thx

Linda

[Handwritten signature]